

# Work Order ID 87025

**\*87025\***

Page 1

Monday, July 09, 2012 9:19:29 PM

Item ID: D4522-045

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Base, Horizontal Swing Arm

Start Date: 7/10/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 7/19/2012 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Run Start

**\*NR1\***

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

**\*NR2\***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4522

B

100

0.00

**\*100\***

Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK AT 1.625"

B.A 12/07/10

2

0

110

0.00

**\*110\***

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER DWG & FOLIO FB106

FOLIO REV: 1

DWG REV: B

29 12-7-12

2

DEBURR

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Base, Horizontal Swing Arm

Start Date: 7/10/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 7/19/2012 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00  0.00		29	12-7-12	2			
130 <b>*130*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00	DAS 14 2-83	12/07/16		2			
140 <b>*140*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				2	76	12-7-17	

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Item ID: D4522-045

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Base, Horizontal Swing Arm

Start Date: 7/10/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 7/19/2012 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Run Start **\*NR1\***

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC7-Inspect Chemical Conversion Coat

0.00

**\*150\***

QC

Memo

0.00

Quality Control

2 0 12717

160

0.00

**\*160\***

Small Fab

Memo

0.00

Small Fab

INSERT HELI-COIL

2 0 120717

170

QC5- Inspect part completeness to step on W/O

0.00

**\*170\***

QC

Memo

0.00

Quality Control

DAS  
16  
9-83  
12/7/1712 \_\_\_\_\_

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Monday, July 09, 2012 9:19:29 PM

Item ID: D4522-045

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Base, Horizontal Swing Arm

Start Date: 7/10/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 7/19/2012 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Run Start

**\*NR1\***

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Stop

**\*NR2\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

Identify as per dwg & Stock Location: **ST 117** 0.00**\*180\***

Packaging

Memo

0.00

Packaging

**24** **12-7-17**

190

QC21- Final Inspection - Work Order Release

0.00

**\*190\***

QC

Memo

0.00

Quality Control

**12/7/19** **MF**  
**12-07-18**

# Picklist Print

Monday, July 09, 2012 9:19:29 PM

Page 1

Work Order ID: 87025

Parent Item: D4522-045

Parent Item Name: Base, Horizontal Swing Arm

Start Date: 7/10/2012

Required Date: 7/19/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 12-02-16 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6B1.000X02.000

Purchased

No

f

70.3480

0.29

6061-T6 Bar 1.00 x 2.00

Location

Loc Qty

Loc Code

MAT

22.748

112567

0

→ 121660

22.748

MAT004

47.6

122081

23.6

122321

24

0.290 FT

MS21209-C0820

Purchased

No

Each

10.0000

4

Threaded Insert, 8-32 UNC x 0.33 LG

Location

Loc Qty

Loc Code

ST305

10

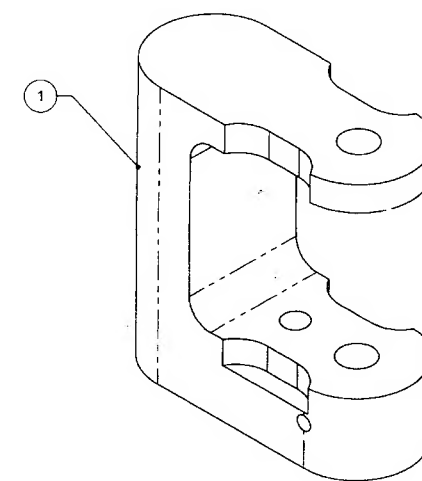
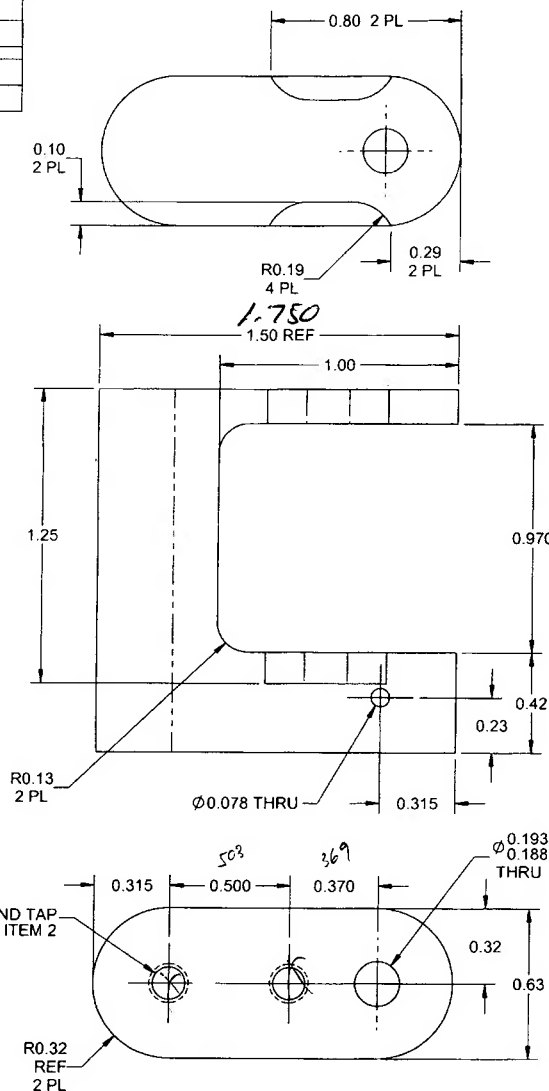
120593

10

4

② FF 12-07-17

ITEM	QTY	P/N	DESCRIPTION
	X	D4522-045	BASE, HORIZONTAL SWING ARM
1	1	D4522-3	BASE, HORIZONTAL SWING ARM
2	2	MS21209-C0820	THREADED INSERT, 8-32 UNC X 0.33 LG



- NOTES:
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 OR  
AMS 4117/4128/4115/4116 OR QQ-A-200/8 OR  
AMS 4160 OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: PER DART QSI 044 6.6 OR 6.7
  - 7) WEIGHT: 0.07 lbs

**D4522-045 BASE, HORIZONTAL SWING ARM**

DESIGN	RP	<b>DART AEROSPACE LTD</b>	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4522	SHEET 9 OF 23
APPROVED		TITLE	SCALE
DE APPR.		DOOR LATCH ASSY (412)	NTS.
DATE	12.04.17	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

172/2 086 188/2 087

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 87025
<b>Description:</b> BASE, HORIZONTAL SWING ARM		<b>Part Number:</b> 4522 - 045
<b>Inspection Dwg:</b>	<b>Rev:</b>	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.80 2pl	+/- .030	.790	/		129.02	
.10 2pl	+/- .030	.097	/			
.29 2pl	+/- .030	.300	/			
R.19	+/- .030	.188	/			
1.54	+/- .030	1.540	/			
1.50	+/- .030	1.502	/			
1.00	+/- .030	1.008	/			
.970	+/- .010	.972	/			
1.25	+/- .030	1.250	/			
.42	+/- .030	.419	/			
.23	+/- .030	.235	/			
R.13	+/- .030	.125	/			
.078	+/- .005 - .001	.078	/			
.315	+/- .010	.318	/			
.193	.193 / .188	.192	/			
.315	+/- .010	.315	/			
.500	+/- .010	.503	/			
.370	+/- .010	.369	/			
.32	+/- .030	.316	/			
.63	+/- .030	.632	/			

<b>Measured by:</b> RP	<b>Audited by:</b> DAS 14	<b>Preliminary Approval:</b>
<b>Date:</b> 12.7.16	<b>Date:</b> 12/07/16	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15